

step - 06/09

Dart Aerospace Ltd.

Date: Wednesday, 6/6/2007 1:58:45 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL MOUNT ANGLE
Job Number : 32804	
Estimate Number : 10780	
P.O. Number : <u>N/A</u>	Part Number : D32083
This Issue : 6/6/2007	Drawing Number : D3208 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u>	Drawing Revision : A1
Previous Run : 28923	Material : <u>N/A</u>
Written By : _____	Due Date : 6/26/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 10 Um: Each
Comment : Est: B 04.05.25 Material changed for Step 4 KJ/JLM Est Rev:C Now on Waterjet 06-10-12 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.0692 sf(s)/Unit Total : 0.6920 sf(s)  
6061-T6 .063 Sheet  
Material: 6061-T6 (QQ-A-250/11) 0.063" thick  
(M6061T6S.063)  
Batch: M18556

SAD 07/06/13

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D3208  
Dwg Rev: A1  
Prog Rev: \_\_\_\_\_

2-Deburr if necessary

SAD 07/06/13

10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/13

10

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/06/13 (+14)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
Deburr D3208-3  
Form D3208-3 as per Dwg D3208  
Polish any marks on part within 01. of Dwg D3208

UMF 07-06-25

SB 07/09/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/13	2.0	One Part was Scrap because jet off set had to be change to 0.017 instead of the regular 0.015	<i>[Signature]</i> AS1012	<del>Scrap, destroy, replace</del> Are Acceptable,	SAU 07/06/13	<i>[Signature]</i> 070613	<i>[Signature]</i> AS1012	<i>[Signature]</i> 070613

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:58:45 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL MOUNT ANGLE

Job Number: 32804

Part Number: D32083

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 02/09/05 (11)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 07/09/05 (11)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

Pa 11/9/6 (11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5776

10/12/04-011  
Pa 02/9/6 (11)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Pa 07/09/06 (11)

Job Completion



W 07-09-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

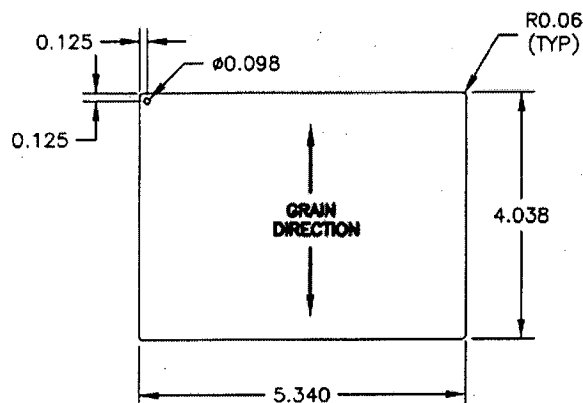
**NOTE:** Date & initial all entries



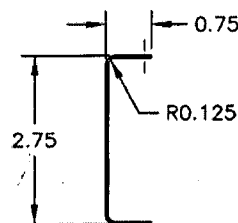


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A	04.01.27	NEW ISSUE	
AI	# 04.05.25	CHANGE DIM; NOTE 3) CHANGE	

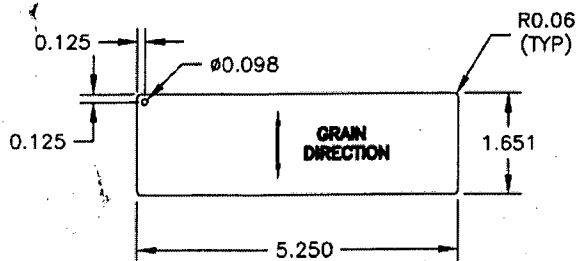
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04.04.05



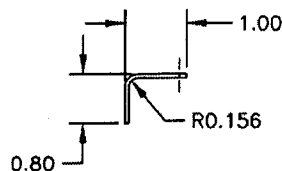
2 D3208-1 DOUBLER  
FLAT PATTERN



D3208-1 DOUBLER  
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE  
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE  
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



- 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)

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WORK ORDER  
NO. 32804

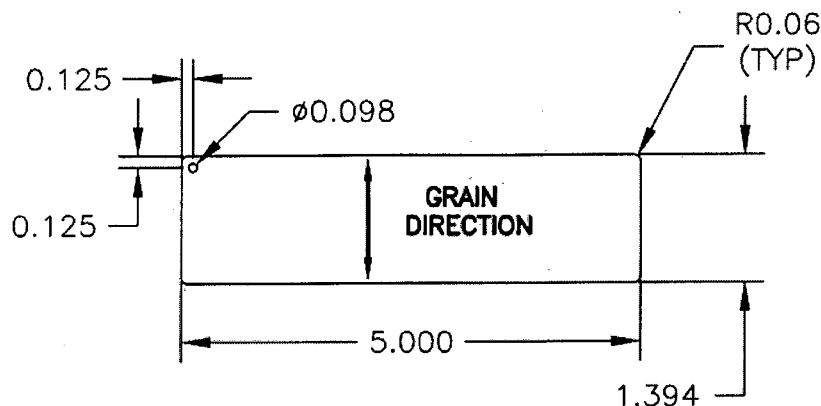
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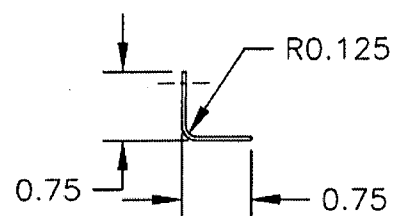


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DATE 04.01.27	TITLE DOUBLER		SCALE 1:2

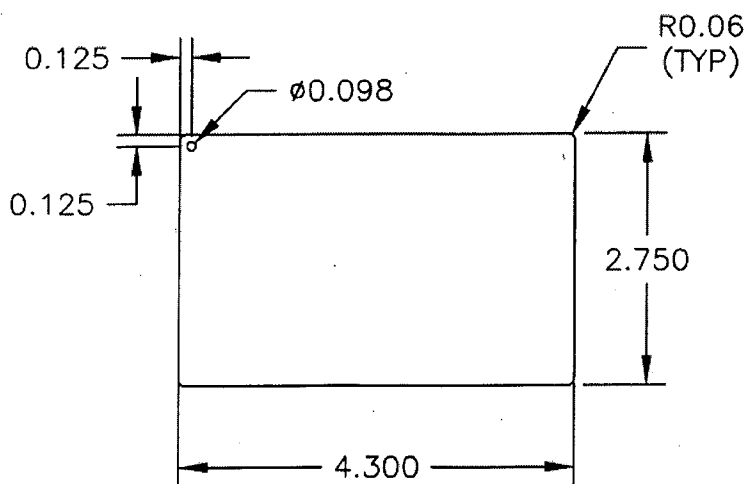
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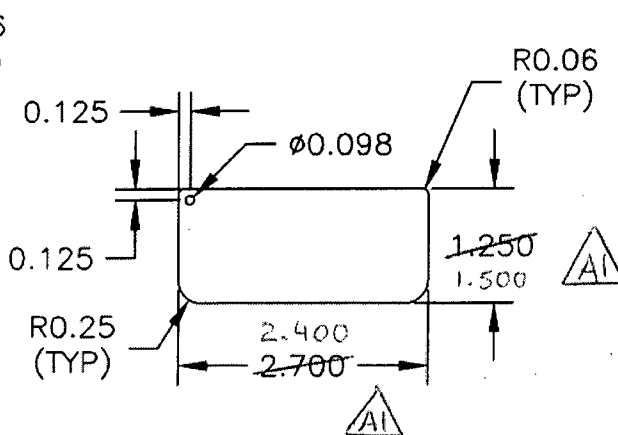
2 D3208-5 MOUNT ANGLE  
FLAT PATTERN



D3208-5 MOUNT ANGLE  
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

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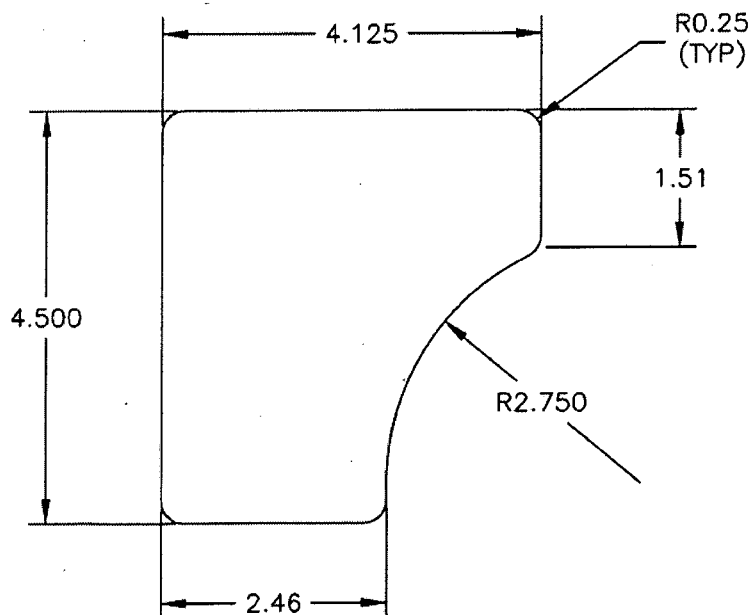
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04.04.05 off



**D3208-9 DOUBLER**

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